250 West 96th Street, Suite 150, Indianapolis, IN 46260
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PRODUCT DATA SHEET

GenFlex G-400 Seam Adhesive

DESCRIPTION

GenFlex G-400 Seam Adhesive may be used to seam GenFlex EPDM sheets in fully adhered, mechanically attached, and ballasted systems. GenFlex G-400 Seam Adhesive has excellent adhesion to EPDM and has excellent initial strength at 158°F (70°C).

PHYSICAL PROPERTIES

PROPERTY	TYPICAL VALUES
Base	Synthetic Polymers
Color	Black
Solids	26% Minimum
Solvents	Toluene, Hexane, Xylene
Viscosity	2900-3700 cps, RVF Brookfield, #3 Spindle @ 10 RPM
Weight	7.3 lb (12.5 kg/L) Nominal
Specific Gravity	.87 Nominal
Flash Point	0°F (-17.8°C) TCC

INSTALLATION

NOTE: Ensure both mating surfaces are cleaned and no moisture is present on the splicing surfaces.

1. Position the top membrane to overlap the bottom membrane by a minimum of 3" (76 mm). With a grease pencil, mark the bottom membrane 1/2" (13 mm) from the edge of the top membrane. Fold the top membrane back 12" to 15" (305 mm to 375 mm).
2. Using a clean rag saturated with GenFlex Cleaner, thoroughly clean an area on both sheets at least 4" (102 mm) wide where the adhesive will be applied. Remove all visible talc and maintain surfaces free from all moisture, oil, and other contaminants. Thoroughly clean the factory seam. Allow the cleaned membrane to dry completely.
3. Stir GenFlex G-400 Seam Adhesive thoroughly before using. DO NOT THIN! Adhesive may be applied with a roller (minimum 3/8" (9.5 mm) nap, or painted on with a brush. For brush application, DO NOT CUT brush; use a back and forth conventional painting stroke. Apply an even coat of adhesive to each membrane surface to be spliced. Avoid globs and puddles.
4. Allow adhesive to dry until slightly tacky to a dry finger touch. Typical time between application of adhesive and mating surfaces will be about 30 minutes.
5. Roll the top membrane back to the bottom membrane and allow it to fall freely into place without stretching. Immediately apply pressure to bring the bonding surfaces into complete contact.
6. Hand roll the entire splice using a Teflon coated or rubber hand roller, ensuring good contact between the membranes, first at a right angle toward the outer edge and then along the length of the splice.
7. IMPORTANT: Using a clean rag saturated with GenFlex Cleaner, thoroughly clean an area on both sheets at least 2" (51 mm) each way from the edge of the splice.
8. Apply GenFlex Edge Caulk to ensure a water tight seal. Use a "high profile" bead of caulk along the entire edge of the splice. Ensure bead covers factory seam. DO NOT SCREED!

APPLICATION PRECAUTIONS

1. Ensure both mating surfaces are cleaned and no moisture is present on the splicing surfaces.
2. For brush application, DO NOT CUT brush; use a back and forth conventional painting stroke.
3. Avoid globs and puddles.
4. Do not apply edge caulk immediately after making splice, but apply no less than 2 hours after making splice.
5. All splices shall be caulked before the day's end.

PRODUCT DATA

SIZE	CONTENTS	PRODUCT #
1 gallon (3.8 Liter)	6 per Carton	10083

LEED INFORMATION

Recycled Content
- Post Consumer 0%
- Post Industrial 0%

V.O.C. Content 615 g/L

STORAGE

Store indoors in original unopened containers at a temperature between 60ºF and 80ºF (16ºC and 27ºC) for maximum shelf life. Do not store on roof in direct sunlight. When exposed to lower temperatures, restore to room temperature prior to use.

SHELF LIFE

12 months; shelf life will be shortened if exposed to elevated temperatures.

PRECAUTIONARY DATA

This product is extremely flammable. Vapors may cause flash fires. Vapors may ignite explosively under certain conditions. Keep away from fire, sparks, and sources of heat. Extinguish all flames and pilot lights. Turn off electronic motors, stoves, or heaters, or any source of ignition during use and until all vapors have been dispersed.

Do not smoke.
Close containers after use.
Use with adequate ventilation.
Avoid prolonged breathing of vapors.
Avoid prolonged and repeated contact with skin.
Store at temperature of 80°F (27°C) or below for maximum shelf life.
Keep out of reach of children.
Keep away from eyes.
Use chemically resistant gloves.
Review Material Safety Data Sheet prior to use.